

Date: Friday, 30/05/2008 10:12:35 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 39597		
Estimate Number	: 11181		
P.O. Number	:	Part Number	: D32941
This Issue	: 30/05/2008 S.O. No. :	Drawing Number	: D3294 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: A1
Previous Run	: 37035	Material	:
Written By	:	Due Date	: 10/06/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JUL 08.5.30</u>		
Comment	: Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
-----	-------------	--------------------



Comment: Qty.: 2.1072 sf(s)/Unit Total : 42.1449 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3294-1
 Batch: 107 460 HB 8-6-3

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3294
 Dwg Rev: A1
 Prog Rev: A1

HB 8-6-3

2-Deburr if necessary

HB 8-6-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-6-3**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5 08/06/05 cont
x2

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

a/y Done at step 2.2
5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.06.11	2	SET GRAIN DIRECTION AT 45° REF DS EMAIL	B 26-11			IP 08.06.11 PC 081042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:35 AM
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Process Sheet

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Drawing Name: BRACKET

Job Number: 39597

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3294

SIB 08/06/10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/10 (21) cocotes

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 08/06/10 (21)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316

(21X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50
320°F
12:20

M-1 08/06/10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FZ 08/06/10 (21)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 211

8/6/10

(21X)

SP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12

Job Completion



12 08/06/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

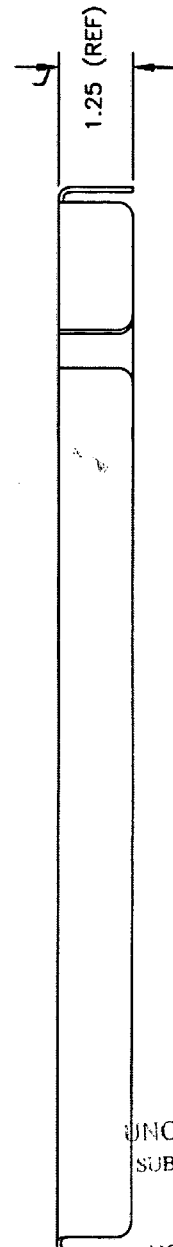
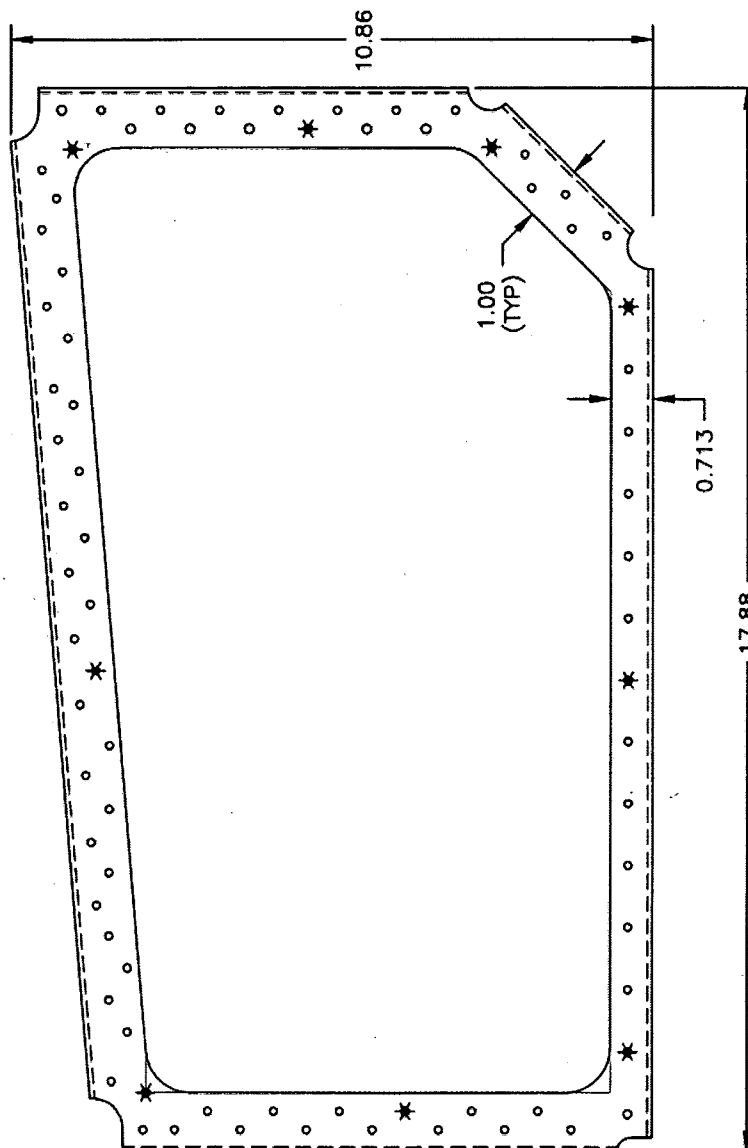
NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3294	REV. A SHEET 1 OF 2
DATE 04.06.28		TITLE BRACKET	SCALE 1:3
A	04.06.28	NEW ISSUE	
AI	<i>GR</i> 05.06.13	12.97 WAS 13.03, AS MANUFACTURED	

RELEASED
04.07.12 *[Signature]***D3294-1 BRACKET**

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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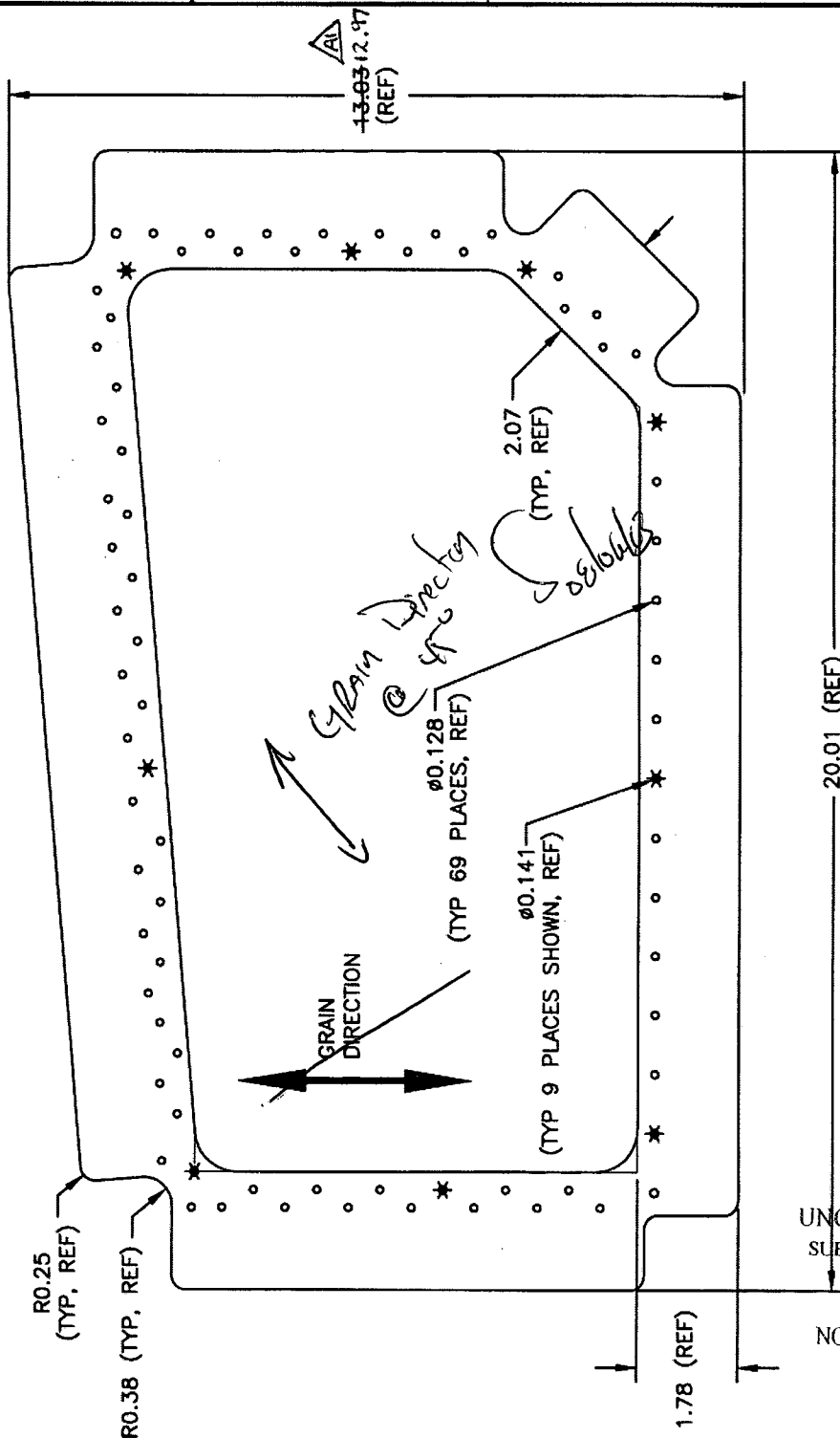
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3294	REV. A SHEET 2 OF 2
DATE 04.06.28		TITLE BRACKET	SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED
R 04.07.12



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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 11, 2008 3:28 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Peter Hum'
Subject: RE: NCR D3294-1

Chris,

Makes sense to me. Acceptable deviation.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, June 11, 2008 8:01 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; Peter Hum
Subject: NCR D3294-1

David,

We set the grain direction at 45 degrees for the D3294-1 Bracket (floor bracket for D350-567 vert ref window).
The bracket was cracking during bending when done per dwg. Is this acceptable?

Mike,

Dwg D3294 Rev. A should be updated to change the grain direction to 45 degrees.

-Chris

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Version: 7.5.524 / Virus Database: 270.2.0/1494 - Release Date: 6/10/2008 7:22 AM

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